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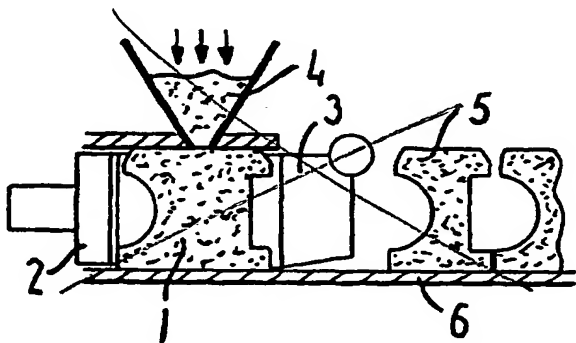
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(54) Title: INDEPENDENT CONTROL OF SQUEEZE PLATE VELOCITY DURING FLASKLESS MOULDING



(57) Abstract: The present invention relates to a method of producing mould parts (5) on a string moulding apparatus comprising a moulding chamber (1) between a squeeze plate (2) and a pivoted squeeze plate (3) in which both the squeeze plate (2) and the pivoted squeeze plate (3) can move in a direction towards each other and a direction away from one another comprising the steps of introducing a compressible particulate moulding material (4) in the moulding chamber (1) and then squeezing the moulding material (4) by moving the squeeze plate (2) and the pivoted squeeze plate (3) towards one another wherein the velocity of the squeeze plate and the velocity of the pivoted squeeze plate are controlled independent from one another during the squeezing of the mould part (5). Further the invention relates to a string moulding

apparatus for producing mould parts (5) comprising a moulding chamber (1) between a squeeze plate (2) and a pivoted squeeze plate (3), in which mould parts (5) are produced by introducing a compressible particulate moulding material (4) in the moulding chamber (1) and then moving the squeeze plate (2) and the pivoted squeeze plate (3) towards each other to squeeze the mould part (5) wherein the velocity of the squeeze plate (2) and the velocity of the pivoted squeeze plate (3) are controlled independently from one another during squeezing of the mould part (5).

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